



CEWELD E AlSi 12

TYPE Coated electrode for fast joining of cast aluminum alloys with more than 7% Si (AlSi12, 4047A).

APPLICATIONS CEWELD® E AlSi 12 is for joining aluminum alloyed with copper, silicon, and magnesium. Also excellent for joining dissimilar grades of aluminum. For welding broken gear parts and other casting parts, also ideal for cladding or rebuilding wornout parts, Engine blocks, cylinder heads, tanks, containers, frames, lorry tipper.

PROPERTIES CEWELD® E AlSi 12 have a very good weldability with good penetration and porosity free deposit, Unique self lifting slag and improved coating against moisture pick up. Start by using the upper portion of the amperage range. Feed the electrode quickly and move fast maintaining a very close arc gap.

CLASSIFICATION

AWS	A 5.3: E 4047
EN ISO	18273: E AlSi12(A)
W.Nr.	3.2585
FM	23

SUITABLE FOR **Al 4047A (AlSi12)**
 Cast Aluminium with more than 7% Silicium,
Mat.n: 3.2211, 3.2315, 3.2371, 3.2373, 3.2381, 3.2383, 3.2581, 3.2583, 3.3206,
 G-AlSi12, G-AlSi12(Cu), G-AlSi10Mg, G-AlSi10Mg(Cu), G-AlSi9Mg, AlMg1SiCu, AlMg0,5Si, AlMgSi1,
 G-AlSi5Mg
Iso. n: 6061, 6063, 6082
 EN AC-42100 [AlSi7Mg0.3], EN AC-43000 [AlSi10Mg(A)], EN AC-43200 [AlSi10Mg(Cu)], EN AC-43300 [AlSi9Mg], EN AC-44000 [AlSi11], EN AC-44200 [AlSi12(A)], EN AC-47000 [AlSi12(Cu)]

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

Si	Mn	Ti	Fe	Cu	Zn	Al
12	0.05	0.08	0.15	0.3	0.2	Rem.

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	150	250	14	HRc

REDRYING Not required

GAS ACC. EN ISO 14175



CEWELD E ALSi 12

E ALSI 12 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2	8720663406743

E ALSI 12 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2	8720663406750

E ALSI 12 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2	8720663406767